

Work Order ID 74735

Wednesday, October 05, 2011 2:35:33 PM



Page 1

Item ID: D3512-1

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 10/5/2011 Start Qty: 12.00

Required Date: 10/14/2011 Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

H

Date: *11-10-5*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3512 | Rev C | | | | | | | | |

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3512 ☐ Dwg Rev: *C* ☐ Prog Rev: *C* ☐ 2-
Deburr if necessary

384 .063

B11-10-24

(17)

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B11-10-24

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

11 10 28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 10/14/2011 Req'd Qty: 12.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130  Brake NC Brake NC | NC BRAKE Memo Deburr if necessary <input type="checkbox"/> Form as per dwg D3512 using DT8179 | 0.00 0.00 | | | | (15) | | | |
| 140  QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | | | | 11 | 10 | 31 (15) |
| 150  Large Fab Large Fab | Large Fab Memo Weld hard surface using DT8874 as per Dwg D3512 & QSI 004 <input type="checkbox"/> Qty Description Batch <input type="checkbox"/> A/R 2059b Hardcoat Rod 1119373 | 0.00 0.00 | | | | (15) | | | MAL/2 11/11/16 |

| W/O: | | WORK ORDER CHANGES | | | | | |
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Required Date: 10/14/2011 Req'd Qty: 12.00



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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160 QC Quality Control | QC10- Inspect visual per QSI004- ground welds Memo | 0.00 0.00 | | | | | | | |
| 170 QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | | | | | | |
| 180 Powdercoat Powder Coating | Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: 8:30 FINISH TIME: 3200F OVEN TEMPERATURE: 9:00 | 0.00 0.00 | | | | | | | |

(15)

15X PM 10/11/17

M 118489

| W/O: | | WORK ORDER CHANGES | | | | | |
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Item ID: D3512-1

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Setup Start



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Stop



Item Name: Wearplate

Start Date: 10/5/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

15 BR 11-1177.

200

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

C. J. J. (15)

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/11/21 (15)

11-11-17 (15)

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Wednesday, October 05, 2011 2:35:38 PM

Page 1

Work Order ID: 74735



Parent Item: D3512-1



Parent Item Name: Wearplate




Start Date: 10/5/2011

Required Date: 10/14/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 06-06-20 JLM
IPP Rev:B Now SS as per Rev B 06-12-15 JLM
IPP Rev:C Rev C dwg 07-12-06 DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status | | | | | | | | | |
|---|------------------------|-----------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---|----------------|--------|-----------------|----------------|-----------------|--------|------|--|--------|------|--|
| M304S16GA  304/316 Sheet .063 | | Purchased | | No | | 100 | sf | 94.2000 | 0.261 | 3.296842 | | | | | | | | | | | | |
|  | | | | | | | | | | | | | | | | | | | | | | |
| B11-10-29 | | | | | | | | | | | | | | | | | | | | | | |
| <table><tr><th><u>Location</u></th><th><u>Loc Qty</u></th><th><u>Loc Code</u></th></tr><tr><td>MAT020</td><td>94.2</td><td></td></tr><tr><td>118964</td><td>94.2</td><td></td></tr></table> | | | | | | | | | | | | | | <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> | MAT020 | 94.2 | | 118964 | 94.2 | |
| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | | | | | | | | | | | | | | | | |
| MAT020 | 94.2 | | | | | | | | | | | | | | | | | | | | | |
| 118964 | 94.2 | | | | | | | | | | | | | | | | | | | | | |
| 118964 | | | | | | | | | | |  | | | | | | | | | | | |

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NOTE: Date & initial all entries

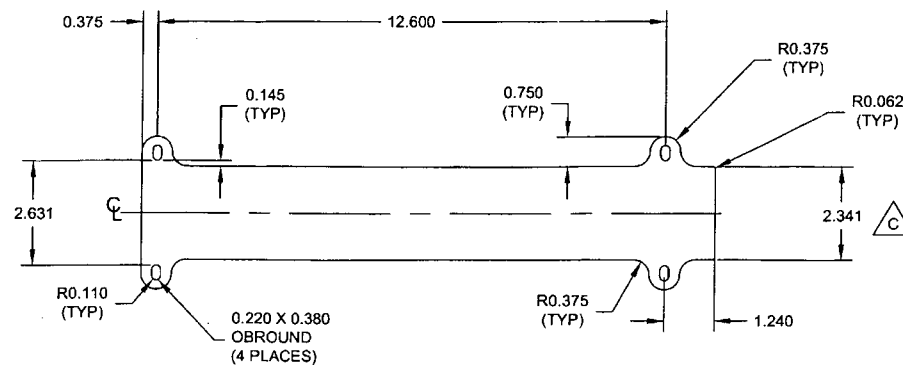
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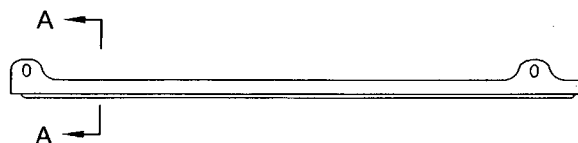
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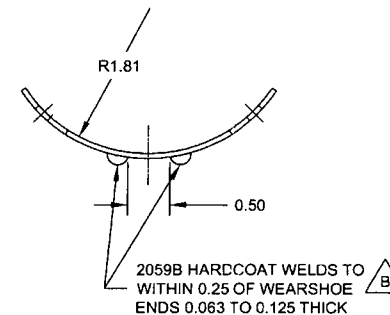
NOTE: Date & initial all entries



D3512-1F FLAT PATTERN



D3512-1 BENDING DETAIL



SECTION A-A
SCALE 2:3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74735

RELEASED
07.11.16



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.31 lbs

| C | ENLARGE OBOUND FOR EASIER ASSEMBLY UPDATE DRAWING FORMAT ADD WEIGHT | PH | 07.10.05 |
|------------|---|----|----------|
| B | CHANGE MATERIAL TO STAINLESS STEEL | PH | 06.10.27 |
| A | NEW ISSUE | PH | 06.04.21 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 07.10.05 | | |

DART AEROSPACE USA, INC
PORT HADLOCK, WA
DRAWING NO. D3512
TITLE WEARPLATE
REV. C
SHEET 1 OF 1
SCALE 1:3

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WRITTEN PERMISSION FROM DART AEROSPACE USA, INC

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